

T & R WILLIAMSON LTD

A DIVISION OF THOMAS HOWSE LTD

RAIL SPEC TRANSPORT PAINT

UNDERCOAT

CAT NO: 81150

T D NO: 151-165



By Appointment
to HM The Queen
T&R Williamson Ltd
Manufacturers
of Coatings and Paints Ripon

TECHNICAL DATA SHEET

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PRODUCT FEATURES

Whilst the product has excellent brushing and flow properties, it can also be applied by spray.

THEORETICAL VOLUME SOLIDS:

45%

POT LIFE OF MIXTURE:

N/A

FLASH POINT:

Above 32°C

VOCs PER LITRE:



On average
300-400g/litre.
(Depending on
colour.)

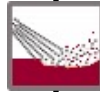
2004/42/IIB(d)420 The EU limit for this product category IIB(d) in ready to use form is a maximum of 420g/Litre.



DESCRIPTION

Spec 81 Undercoat is a one component air drying undercoat based on a modified alkyd resin and formulated to give good flow, intercoat adhesion and gloss 'hold up'.

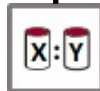
It is suitable for overcoating with one component gloss finishes, the undercoat has a traditional semi-gloss finish.



SURFACE PREPARATION

Refer to the relevant vehicle maintenance painting schedule regarding vehicles previously coated with single component materials from standard CR/TT1081 or BR SPEC 81.

For further information refer to section on painting procedure.



MIXING RATIO*

This is a one pack product. No mixing Required

*All pigmented fluid paints have a tendency to settle and separate over a period of time. In order to ensure that the paint is evenly dispersed before use it is essential that the material in the can is thoroughly hand stirred after opening. In difficult circumstances, the use of a mixing machine or mechanical stirrer will be more effective.



SPRAYING VISCOSITY

22 - 25 Seconds *	reduce as necessary *
Conventional	Airless

*In a 4mm Flow Cup. (Spraying viscosity and thinning will depend on ambient conditions, spray equipment used and desired finish.)

SHELF LIFE

12 months from the date of manufacture, stored in original unopened container at a temperature between 10°C and 25°C

SPREAD RATE:

Approx. 13m²/litre dependant upon application

EWC CODE:

08 01 11



METHODS OF APPLICATION

Method	Brush	Conventional Spray	Airmix Airless Spray	HVLP
Thinning	Supplied ready for use	Up to 5% SR 48 or up to 5% SR 25	Ready for use	Up to 5% SR 48 or up to 5% SR 25
Number Of Coats	1 full coat	1 coat	1 full coat	1 coat
Spray Gun Fluid Tip	N/A	1.4 – 1.8mm	11-13 thou	FF 1.4mm
Fluid Feed	N/A	Suction or pressure	1000-1500 psi/ 70-105 bar	Pressure
Air Cap	N/A	30	N/A	153/13
Air Pressure	N/A	55-60 psi / 4 bar	80-100 psi/ 5-7 bar	30 psi/ 2 bar gun-10 psi/0.7 bar
Recoat Time	16 hours (handleable in 3 hours at 20°C)			
Intercoat Preparation	If required, lightly abrade to de-nib the surface and wipe with a tac rag to remove dust etc.			



THINNERS

Up to 5% Special Thinners 36601SR001



DRYING TIMES

Air dried: Handable after 5-6 hours at 20°C
 Fully dry 16 hours at 20°C



RECOMMENDED FILM THICKNESS

Wet Film Thickness	75 Microns
Dry Film Thickness	35 Microns



CLEANING

Equipment Cleaning using Williamsons Thinners SR48, SR36 or Gunwash